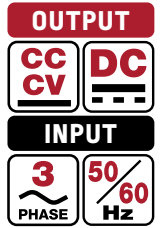


FLEXTEC MULTI-PROCESS WELDERS

FLEXTEC 350X, 500X, 650X



It does not get much simpler

On the construction site or in fabrication shops, it pays to keep it simple. The Flextec platform is designed for that kind of environment. These multi-process welders are easy to setup and easy to operate, yet rugged and flexible enough to be used in construction, fabrication, shipbuilding and other heavy-duty applications.

Simple

- Streamlined operator panel minimizes setup time with easy process selection.
- Plug in to any 380-600V 3 phase power.

Reliable

- Built on industry proven design elements of other popular Lincoln Electric welders.
- Components designed to run cool for long life in high temperature environments.
- Fully encapsulated and environmentally protected electronics.
- Engineered for outdoor use and harsh environments (IP23 rated).

Flexible

- Compatible with across-the-arc, analog, digital or CrossLinc™ feeders.
- Premium multi-process arc characteristics work with all DC wire, stick and TIG processes.
- Choice of models to fit any application and budget.
- Lightweight and portable.

CrossLinc™ Technology

- Full functionality without control cables.
- Enables remote procedure setting at the feeder to improve weld quality.
- Increase arc time with fewer trips to the power source to adjust settings.
- Improves safety by reducing jobsite clutter.

TVT™ True Voltage Technology

- Gives you the true voltage you set by adjusting the power source to compensate for any voltage drop during welding.

TVT™
True Voltage
Technology™



Processes

Stick, DC TIG, MIG, Flux-Cored, Arc Gouging

Applications

Fabrication, Production, Education, Shipbuilding, Construction

Product Number

Flextec 350X: K4284-1

Flextec 500X: K3607-2

Flextec 650X: K3533-1

FLEXTEC FAMILY OVERVIEW

Machine	Product Number	Input (V)	Output (A)		SMAW	GTAW	GMAW	Pulse	FCAW-G	FCAW-S	SAW	Gouging carbon diameter (mm)
			100%	60%								
Flextec 350X	K4284-1	380-575 3 Phase	300	350	•	•	•		•	•		6.4
Flextec 500X	K3607-2	380-575 3 Phase	450	500	•	•	•	•	•	•		9.6
Flextec 650X	K3533-1	380-575 3 Phase	650	750	•	•	•		•	•	•	12.7

SPECIFICATIONS

Machine	Product Number	Input Power	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D (mm)	Net Weight (kg)
Flextec 350X	K4284-1	380-415/460/575/3/50/60	350A/34V/60% 300A/32V/100%	26/23/18	5-425A	477 x 356 x 673	37
Flextec 500X	K3607-2	380/460/575/3/50/60	500A/40V/60% 450A/38V/100%	39/31/31 33/27/27	5-500A	477 x 356 x 673	54
Flextec 650X	K3533-1	380-415/460/575/3/50/60	750A/44V/60% 650XA/44V/100%	57/47/38	10-815A	554 x 409 x 584	75



FLEXTEC 350X Controls

1. Amperage Display
2. Thermal LED
3. Output Control Dial
4. Weld Process Selector Switch
5. Remote Output Control (12-pin Universal Connector)
6. 5-pin ArcLink® WireToggle Switch Feeder Connector
7. 14-pin Wire Feeder Connector Selector Switch
8. Positive and Negative Welding (Dinse style)
9. Voltage Display
10. VRD (Voltage Reduction Device) Indicator Lights
11. CrossLinc™ Indicator Light
12. Hot Start Control Dial
13. Arc Force Control Dial
14. Local/Remote Selector
15. Weld Terminals On/Remote Selector Switch
16. Power Switch
17. Wire Feeder Voltmeter Polarity Selection Switch



FLEXTEC 500X Controls

1. Amperage Display Meter
2. Thermal LED
3. Output Control Dial
4. Hot Start Control Dial
5. Weld Process Selector Switch
6. Local/Remote Selector Toggle Switch
7. Circuit Breaker Reset Button for the 5-pin Wire Feeder Connector
8. 5-pin ArcLink Wire Feeder Connector
9. Positive and Negative 12.7 mm Welding Output Studs
10. VRD (Voltage Reduction Device) Indicator Lights
11. CrossLinc Indicator Light
12. Voltage Display Meter
13. Power Switch
14. Arc Force Control Dial
15. Weld Terminals On/Remote Selector Switch
16. Circuit Breaker Reset Button for the 14-pin Wire Feeder Connector
17. Remote Output Control (12-pin Universal Connector)
18. 14-pin Wire Feeder Connector
19. Wire Feeder Voltmeter Polarity Selection Switch



FLEXTEC 650X Controls

1. Amperage Display Meter
2. Thermal LED
3. Output Control Dial
4. Hot Start Control Dial
5. Weld Process Selector Switch
6. Positive and Negative Welding Output Studs 12.7mm
7. VRD (Voltage Reduction Device) Indicator Light
8. Voltage Display Meter
9. CrossLinc Indicator Light
10. Power Switch
11. Arc Force Control Dial
12. Local/Remote Selector Toggle Switch
13. Weld Terminals On/Remote Selector Switch
14. Wire Feeder Voltmeter Polarity Selection Switch
15. Circuit Breaker Reset Buttons for 42V feeders and ArcLink peripherals
16. 42V or 115V Wire Feeder Selector Switch
17. Remote Output Control (12-pin Universal Connector)
18. 14-pin Wire Feeder Connector
19. 5-pin ArcLink Connector

FLEXIBILITY

Flextec Power sources support multiple weld processes: MIG, TIG, Stick, Gouging, FCAW, SAW. Flextec can be used with nearly all Lincoln Electric wire feeders. Due to available feeder communication connections.

5-pin Control Cable Connection (Lincoln Electric Power Feed® models)

5-pin high-speed digital communication enables advanced process capability and additional operator controls. Allows compatibility with future wire feeder models.



14-pin (Lincoln Electric LF, LN and Flex Feed® models)

14-pin analog communication enables compatibility with most existing Lincoln wire feeders.

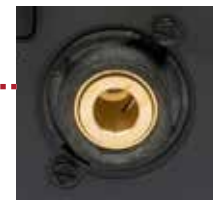


CrossLinc® (Lincoln Electric LN-25X model)

CrossLinc Technology communicates through a standard weld cable to enable voltage or current control at the arc without a control cable.

Across-the-arc Connection (Lincoln Electric LN-25 PRO / Activ8® models)

Across-the-arc feeders connect to the power source using the weld cables. This basic configuration does not use a control cable or CrossLinc Technology, so voltage control is only accessed at the welding power source.



FLEXTEC / WIRE FEEDER SYSTEM FEATURES BY CONNECTION TYPE

• Standard • Specific Models Only

Feeder Connection Type	FEATURES						
	WFS Control	Voltage Control	Memories	Limits/Lockouts (2)	Advanced U/I Controls (1)	Synergic Modes	Pulsing Capability
5-pin Digital (ArcLink)	•	•	•	•	•	•	•
14-pin Analog	•	•	•	•	•		
CrossLinc	•	•					
Across-the-arc	•						

(1) Advanced controls include pre-flow, post-flow, run-in, starting parameters, crater fill, burn back, spot timer and electronic trigger lock.

(2) Synergic Modes enable easy setup with one-knob output control for the system.

RECOMMENDED WIRE FEEDERS AND GUNS	Product Number	350X	500X	650X
LN-25X – Includes CrossLinc and TVT communication technology (comes with bonus Magnum 400 Gun) (image A)	K4267-4M	•	•	•
LN-25X – Includes CrossLinc and TVT communication technology (comes with bonus K126 Gun) (image A)	K4267-1I	•	•	•
LN-25 PRO Dual Power – Includes 14 pin connection (image B)	K2614-6	•	•	•
Flex Feed 74 HT – Four drive-roll, high-torque, industrial semi-automatic wire feeder for general/structural fabrication	K3883-12	•	•	•
Flex Feed 84 – Four drive-roll feeder with heavy duty wire reel stand and contactor for general/structural fabrication (Image G)	K5000-2	•	•	•
Power Feed 84, Heavy Duty Wire Reel Stand, U/I, USB – Four drive roll, digital ArcLink semi-automatic industrial wire feeder built on a modular platform to be used in a variety of applications	K3328-13	•	•	•



RECOMMENDED ACCESSORIES	Product Number	350X	500X	650X
CrossLinc Remote – Adjust voltage or current at the arc. For CrossLinc-equipped welders. See publication MC16-137	K4345-1	•	•	•
Multi-Process Switch – Easily change welding process and polarity without changing cables at the machine (Image D)	K3091-1	•	•	•
12-pin to 6-pin Adapter – Allows 6-pin remote controls (K870, K963-3, K857, K4217-1) to be used with 12-pin Universal Connection	K2909-1	•	•	•
Wireless Foot Pedal with 6-pin Amphenol® – Permits remote adjustment of output (f)	K4217-1	•	•	•
Remote Output Control with 12-pin Universal Connector (25 feet) – Permits remote adjustment of output (Image F)	K857-2	•	•	•
Remote Output Control with 6-pin Amphenol Connector (100 feet) – Permits remote adjustment of output (f) (Image F)	K857-1	•	•	•
Foot Amptrol with 12-pin Amphenol connector (25 ft) – Remote current control for TIG welding (Image E)	K870-2	•	•	•
Hand Amptrol Rotary Track Style, 6-pin Amphenol (25 ft) – Remote current control for TIG welding (f) (Image H)	K963-3	•	•	•
Single Cylinder Inverter and Wire Feeder Cart – Requires K4068-1 mounting bracket for LF, Flex Feed and Power Feed Feeders. Requires locking foot kit for Flexsecs (Image C)	K3059-4	•	•	•
Inverter Cart Mounting Bracket Kit – Use for mounting Flex Feed or Power Feed (to the K3059-4 inverter cart)	K4068-1	•	•	•
Flextec 350X Locking Foot Kit – Allows the Flextec to lock to the inverter cart, Multi-Process Switch, Cool-Arc® 55 water cooler	K4424-1	•		
Flextec 500X Locking Foot Kit – Allows the Flextec to lock to the inverter cart, Multi-Process Switch, Cool-Arc 55 water cooler	K3056-2		•	

(f) Requires the K2909-1 12-pin to 6-pin adapter if used with Flextec® 350X and 500X.

CUSTOMER ASSISTANCE POLICY

Lincoln Electric® business is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric® for advice or information about their use of our products. We respond to our customers based on the best information in our possession at that time. Lincoln Electric® is not in a position to warrant or guarantee such advice and to the extent permitted by law assumes no liability, with respect to such information or advice. As a matter of practical consideration, we also cannot assume any responsibility for updating or correcting any such information or advice once it has been given. The provision of information or advice does not create, expand or alter this warranty. Lincoln Electric® is a responsive manufacturer, but the selection and use of specific products sold by Lincoln Electric® is solely within the control of, and remains the sole responsibility of the customer. Many variables beyond the control of Lincoln Electric® affect the results obtained in applying this type of fabrication methods and service requirements. Subject to Change – This information is accurate to the best of our knowledge at the time of printing.

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